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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	21378/79
<b>Description:</b> Bracket Assembly	<b>Part Number:</b>	D3121-043
04.08.23/14 C2 E 04.02.17/14 04.08.23/14		D3121-044
<b>Dwg:</b> D3121 Rev. B page 1, 3, 5	<b>Qty:</b>	4 Kits
D3121-043 replaces Premier P/N B30-23000-37		
D3121-044 replaces Premier P/N B30-23000-38		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	LD	04.08.23	4
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: M14773	WZ	04/09/20	4
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	EE	04.11.16	4
4	QC2	Inspect parts as they come off the CNC machine	EE	04.11.16	4
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	EE	04.11.16	4
6	QC2	Inspect parts as they come off the CNC machine	EE	04.11.16	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	EE	04.11.16	4
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	LD	05-01-20	4
9	QC5	Second check D3121-13 and D3121-14	LD	05/01/24	4
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: 2 D3121-21 Qty Part Number Description Batch 2 D3121-17 Washer B21881A 2 D3121-19 Bearing 2 MS24694 S50 Screw B21855 2 D3121-241	LD	04/12/08	4
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: 2 D3121-21 Qty Part Number Description Batch 2 D3121-17 Washer B21881A 2 D3121-19 Bearing 2 MS24694 S50 Screw B21855 2 D3121-241	LD	05.01.24	4
12	QC5	Inspect work to Step 10 & 11	LD	05.01.24	4
13	ST	Identify and Stock in Spacedoor cell D3121-043 Qty 4 D3121-044 Qty 4	LD	05.01.27	4
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 129.18 129.22	SAC	05.01.27	4
15	DC	Close W/O 92.14 129.22 Inspect Level 21	LD	05.02.28	4

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
01.12.05	10	Reversmont Change		05.01.28	N/A		

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
01.11.15	3	1 part scrap, first run. 1 part scrap, came out of jig.		Scrap & replace scrap & replace	 01.11.15  01.11.16			

PAR#: N/A

Fault Category: N/A

DQA:

Date: 05/02/24

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

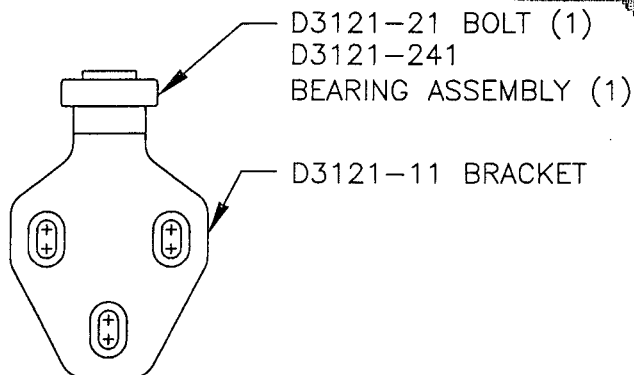
QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

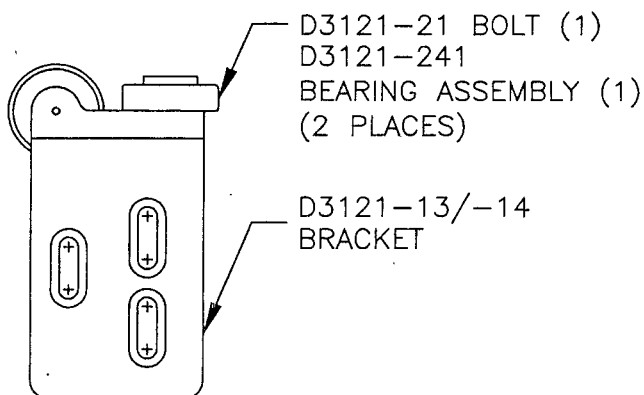


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	CP# 04.03.26	3.17 WAS 4.00; 6.11 WAS 6.14	
C2	# 04.04.26	0.230 WAS 0.238	

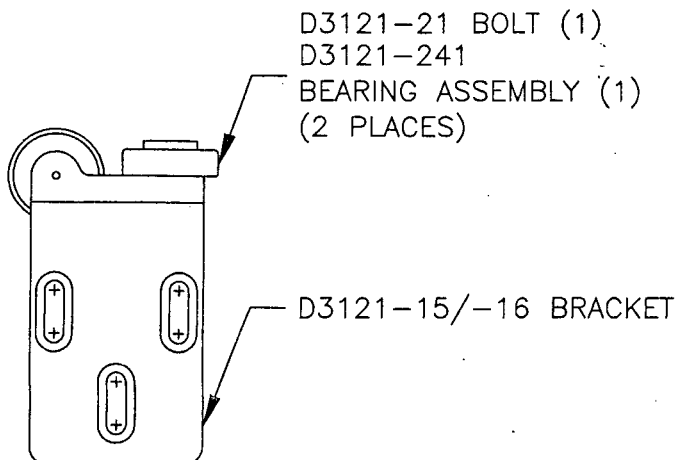
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04.03.01



**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

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WORK ORDER

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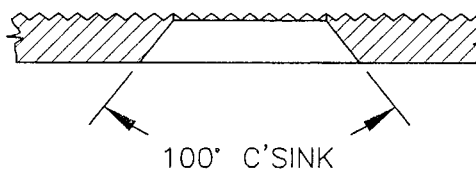
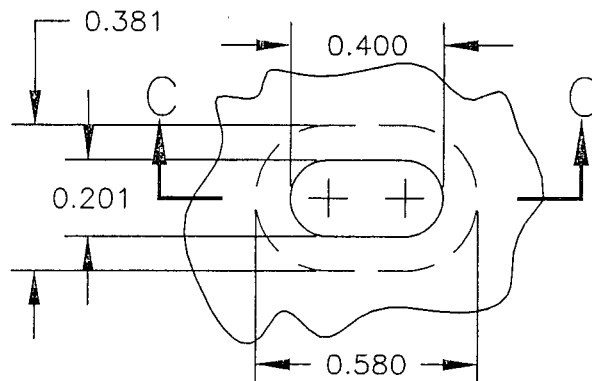
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DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3121	REV. C SHEET 3 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

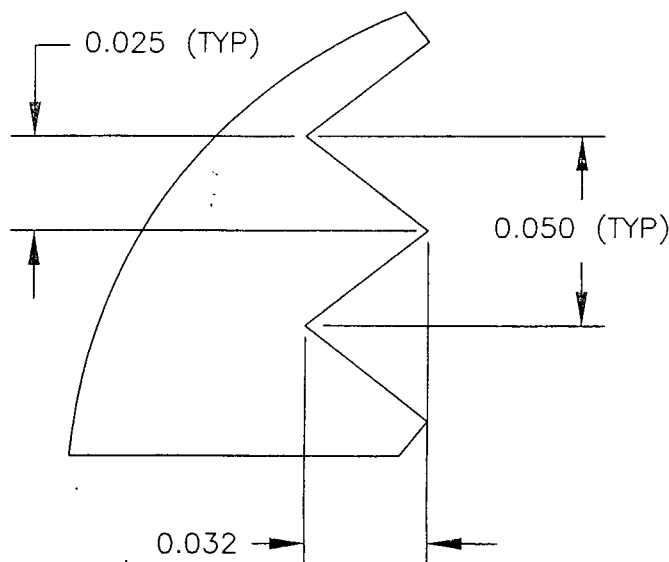
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04.03.01

**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION**  
**C-C**

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



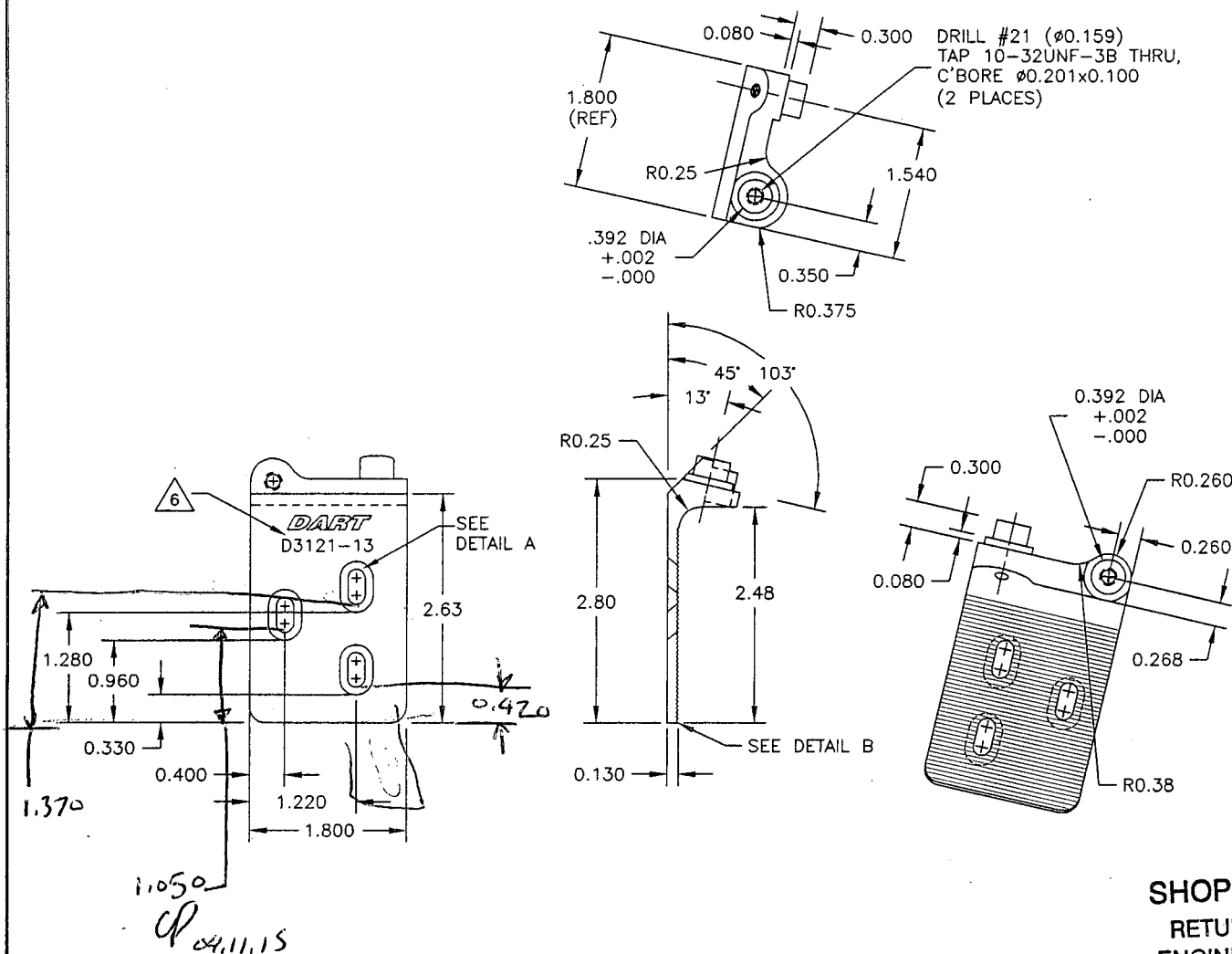
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 5 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



#### D3121-13 BRACKET (SHOWN)

#### D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 23, 2004  
09:51 am

Work Order No : 0021379  
Project Name : D3121-044  
Project For : WK439  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3121-044  
Description : Bracket Assembly  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 08-23-04  
Est Finish Date : 09-15-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 23, 2004  
09:51 am

Work Order No	: 0021378	Department Code:	
Project Name	: D3121-043	Burden Flags	: NNNNNNNN
Project For	: WK439	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3121-043	Invoice Number	:
Description	: Bracket Assembly	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 4	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 08-23-04	Actual Margin	: 0.000%
Est Finish Date	: 09-15-04		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	03121-13
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	$\pm 0.01$	0.301	✓			
0.080	"	0.087	✓			
0.392	$+0.002$ $-0.000$	0.3932	✓			
0.350	$\pm 0.01$	0.348	✓			
1.540	"	1.538	✓			
2.250	"	2.25	✓			
1.800	"	1.801	✓			
1.370	$\pm 0.01$	1.367	✓			
1.050	"	1.048	✓			
0.420	"	0.417	✓			
0.400	"	0.392	✓			
1.220	"	1.212	✓			
2.63	$\pm 0.03$	2.620	✓			
2.80	"	2.796	✓			
2.48	"	2.460	✓			
0.130	$\pm 0.01$	0.137	✓			
0.300	"	0.295	✓			
0.080	"	0.086	✓			
0.260	"	0.257	✓			
0.032	"	0.027	✓			
0.200	"	0.204	✓			
0.400	"	0.397	✓			
0.381	"	0.387	✓			

Measured by: <i>FL</i>	Audited by: <i>ML</i>	Prototype Approval: <i>N/A</i>
Date: 07.11.14	Date: 04.11.14	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



6" caliber  
1" mic  
2" mic

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	03121-14
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	$\pm 0.01$	0.297	✓			
0.080	"	0.078	✓			
0.392	$+0.002$ $-0.000$	0.3934	✓			
0.350	$\pm 0.01$	0.346	✓			
1.540	"	1.536	✓			
2.280	"	2.25	✓			
1.800	"	1.802	✓			
1.370	$\pm 0.01$	1.364	✓			
1.050	"	1.047	✓			
0.420	"	0.416	✓			
0.400	"	0.397	✓			
1.220	"	1.217	✓			
2.63	$\pm 0.03$	2.620	✓			
2.80	"	2.800	✓			
2.48	"	2.470	✓			
0.130	$\pm 0.01$	0.133	✓			
0.300	"	0.294	✓			
0.080	"	0.073	✓			
0.260	"	0.257	✓			
0.032	"	0.024	✓			
0.200	"	0.206	✓			
0.400	"	0.399	✓			
0.381	"	0.382	✓			

Measured by: <i>EC</i>	Audited by: <i>JK</i>	Prototype Approval: <i>N/A</i>
Date: 07.11.16	Date: 10.11.16	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	